

Work Order ID 141726

February 10, 2016 11:15:13 AM

141726

Page 1

Item ID: D2153

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door Prop

Stop

NS2

Start Date: 2/10/2016 Start Qty: 20.00

Required Date: 2/17/2016 Req'd Qty: 20.00

36 FEB 10 2016
DAS
13
9-89
20
20

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: 34

Date: 120160210

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2153

Rev A1

100

PURCHASING

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 31321 Gas Spring P/N: SL13-10 (10lb) Possible
supplier: Spring Lift Corporation **Note: Do not ship by air****Allow an
extra 7 to 10 business days for shipping**Material release note is required

FEB 10 2016

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.01

Packaging

Ensure Material Release Note is attached

36x Sp16-02-16

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Inspect Test Spring is 10lb

36

DAS
38
9-89

FEB 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
				OTHER : ☐							

Page 2

Packaging

DAS
36
9-89

Stamp
16/02/18

AS
38
9-89

FEB 22 2016

DAS
6
9-89

FEB 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

* Work Order ID 141726

141726

Page 3

Item ID: D2153

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Door Prop

Stop *NS2*

Start Date: 2/10/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MC5 FEB 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

February 10, 2016 11:15:29 AM

Page 1

Work Order ID: 141726

141726

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 2/10/2016

Required Date: 2/17/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SL69-BS *SI 69-RS* Ball Stud		Purchased	No			100	Each	149.0000	2	40		16/02/18	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				149					
				M132260				49					
				M134199				100					
D2153P *D2153P* Door Prop		Purchased	No			130	Each	0.0000	1			20/02/16	
D3015-3 *D3015-3* Locknut		Manufactured	No			130	Each	108.0000	2	40		16/02/18	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				18					
				95758				8					
				96151				10					
				ST015				40					
				136803				15					
				140018				25					
				ST025A				50					
				140771				50					

B141459
57x

Picklist Print

February 10, 2016 11:15:29 AM

Work Order ID: 141726

141726

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 2/10/2016

Required Date: 2/17/2016

Start Qty: 20.00

Required Qty: 20.00

NAS1149D0563J

Purchased

No

130

Each

1,240.000

2

40

NAS1149D0563.J

16/02/18

DAS
36
~~9.89~~

Washer

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

184

m133363

14

m133938

170

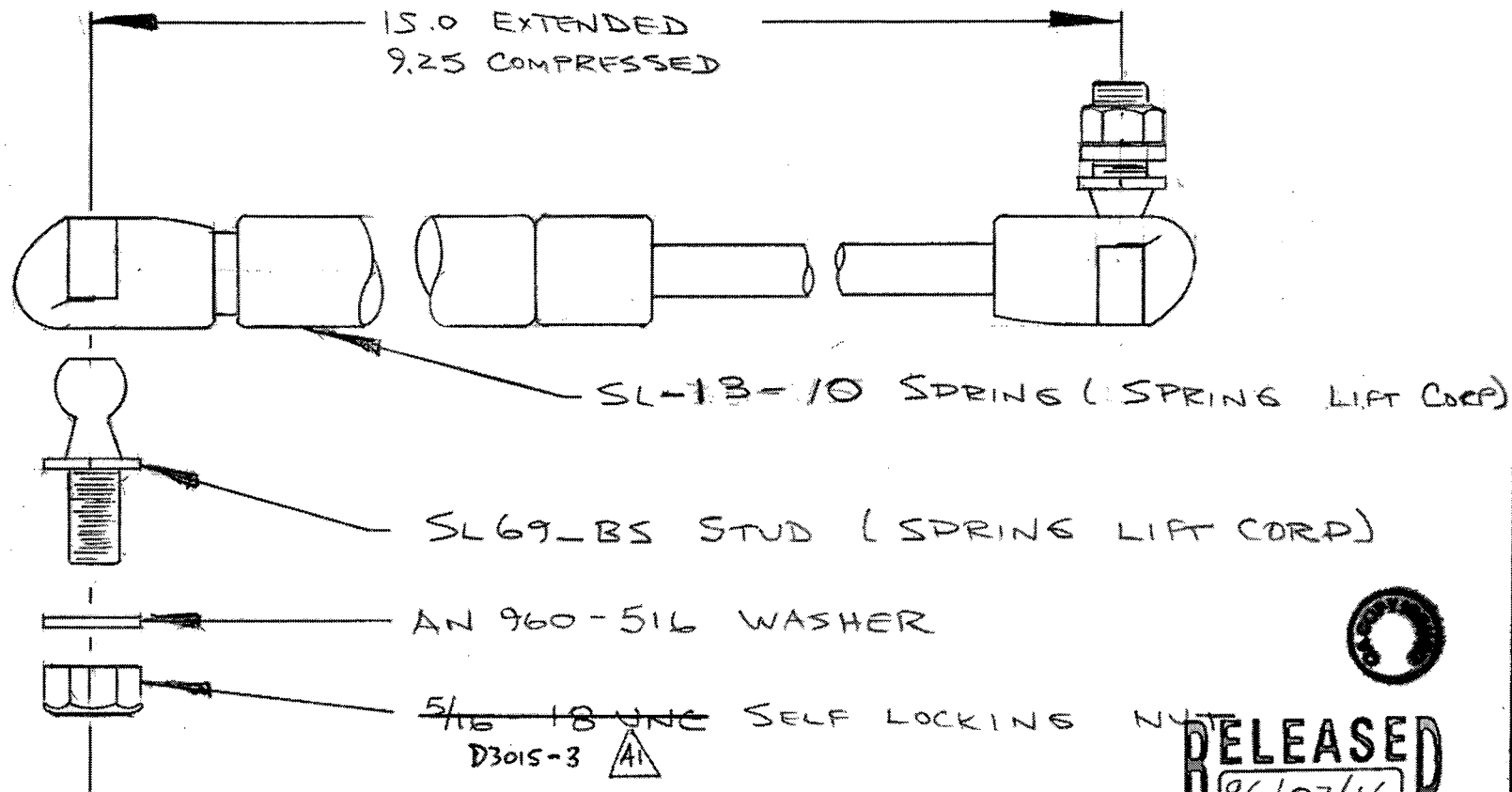
ST269

103

m128257

103

72



RELEASED
96/07/16

120150290 34 141726

01-05-09 CHANGE TO D3015-3 SL 18-10 444 SL32-15		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. IN-HEAD REAR SIDE F-HEAD RAR SIDE 0-DIMPLE DASH NO. OF SHEETS C-COUNTERSINK LENGTH DASH NO. W-SPOTWELD BASIC CODES 8-MMS20470AD 88-MMS20470AD	PART NO. CONTRACT NO. DRAWN DESIGN STRESS CHECKED CLIENT	ITEM DATE 07.2.92 07/2/92	DESCRIPTION DART GAS SPRING ASSEMBLY	MATERIAL DART AERO ACCESSORIES INC. VANCOUVER CANADA	SPEC./VENDOR DZ153
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLES PER AND 10347			LIMITS 1. TOLERANCES — .XX .030 .XXX .010 2. ANGLES 1 1/2° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL 1/4" CENTRE LINES .005	REPORT ALL DISCREPANCIES — DO NOT SCALE	SCALE 1:1 SH1 1 OF 1				

DZ153



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31321**

Purchase Order Date 2/10/2016 2:46:53 PM

PO Print Date 2/10/2016

Page Number 1 of 2

Order From :
ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

VU-ATT001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	616-897-2285	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	FedEx Overnight collect	Currency	USD
Ship Acct:		FOB	Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2153P ✓ AS PER DWG D2153 REV. A B141726 ATTWOOD P/N/SL13-10 (10LB)	Door Prop	2/18/2016 Yes 2/18/2016		36.00 Each	\$13.05	\$469.80
						Line Total:	\$469.80
2	SL69-BS	Ball Stud	2/18/2016 Yes 2/18/2016		100.00 Each	\$4.56	\$456.00
						Line Total:	\$456.00

Note:

2/10/2016



MotorGuide
NEVER STOP

CUST: 68580 MST: 46295-00

TELEPHONE 1616 2291

COLLECT

151793240

BILLTO: DART AERO LTD.
REQ: 02/12/16

PRO NO: 290000343
SHIP VIA: FEDEX STANDARD OVERN
BOL: 00226970005167809

FREIGHT:

*Int'l
FedEx Priority*

F ATTWOOD / MOTORGUIDE
R
O 1016 NORTH MONROE
M LOWELL

MI 49331-0260

INCOTERMS: EXW SHIPPER DOCK

DART AERO LTD.
T 1270 ABERDEEN STREET
O

*tomorrow by
5pm*

HAWKESBURY ON K6A 1K7

CRTS: 2 PO#: PO31321

WGT: 15 DATE: 02/11/16

SPUR: 9

LABEL NO:

--ROUTING GUIDE INFO--

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	ORD		
						LN	QTY	WGT
1	36	W03911	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36	12
1	100	W03131	EA	SL69-BS-1	10MM BALL STUD W/THRD	2	100	3

Sol 60216

===== COMPLETE =====

PICK BY: _____

PAGE: 1 (ONLY PAGE)

ORIGIN ID: GRRR 616 897-9241
ATTWOOD CORPORATION

1016 N. MONROE
LOWELL MI 49331
UNITED STATES

SHIP DATE: 11FEB16
ACTWGT: 15 LB
CAD: 255607/KWCS14061601
Account: S 286139000

TO: 613-632-5200

FedEx
Express

DART AERO LTD.
1270 ABERDEEN STREET
HAWKESBURY

ON K6A1K7 (CA)

AWB



Ref: P0313210000



NZ YMXA

TRK# 5849 4602 1906 Form 0430

ECI 1/2

INTL PRIORITY

REF: P0313210000
DESC1: GAS SPRING 15 EXTC 10 BL SCKT
DESC2: BRACKET 10MM BALL STUD WTHRD
DESC3:
DESC4:
SED: NO EEI 30.36

SLAC:

COUNTRY MFG: MX/US SIGN: keith swann
CARRIAGE VALUE: \$456.00 USD T/C: R 151793240
CUSTOM VALUE: \$925.80 USD D/T: R

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Track: 584946021906

Mode: FedEx Express I	Act Wgt:	14.25	Shipping:	0.00
Invoice: 000002269701	Dim Wgt:	14.30	Special:	0.00
Customer: 68580	DV:	456.00	Handling:	0.00
Date: 02/11/2016	COD:	0.00	Total:	0.00

ORIGIN ID: GRRR 616 897-9241
ATTWOOD CORPORATION

1016 N. MONROE
LOWELL MI 49331
UNITED STATES

SHIP DATE: 11FEB16
ACTWGT: 15 LB
CAD: 255607/KWCS14061601
Account: S 286139000

TO: 613-632-5200

FedEx
Express

DART AERO LTD.
1270 ABERDEEN STREET
HAWKESBURY

ON K6A1K7 (CA)

AWB



Ref: P0313210000



NZ YMXA

TRK# 5849 4602 1906 Form 0430

ECI 1/2

INTL PRIORITY

REF: P0313210000
DESC1: GAS SPRING 15 EXTC 10 BL SCKT
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SLAC:

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Invoice: 000002269701	Dim Wgt:	14.30	Special:	0.00
Customer: 68580	DV:	456.00	Handling:	0.00
Date: 02/11/2016	COD:	0.00	Total:	0.00